

Work Order ID 86135

86135

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June-21-12 8:37:14 AM

Item ID: D3808-041
Revision ID:
Item Name: Seat Rail Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 2.00 ***2***
Required Date: 05/07/2012 Req'd Qty: 2.00 ***2***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/21 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3808	Rev A								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Install Plunger as per Dwg D3808.2-Install helicoils x5 as per Dwg D3808.								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Identify as per dwg & Stock Location <u>262</u>								
Packaging	Memo	0.00							
Packaging									

2 0 FF
12-07-09

(R)

(2x) 12-7-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Seat Rail Assembly

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

Q 12/7/11

ME
12-07-10

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Picklist Print

June-21-12 8:37:18 AM

Page 1

Work Order ID: 86135

86135

Parent Item: D3808-041

D3808-041

Parent Item Name: Seat Rail Assembly

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3808-1 *D3808-1* Seat Rail		Manufactured	No			100	Each	5.0000	1	2			
									**			(2) FF 12-07-09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST262		5							
				83006		5				2			
D3810-1 *D3810-1* Hand Retractable Spring Plunger		Manufactured	No			100	Each	8.0000	1	2			
									**			(2) FF 12-07-09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST064		8							
				57319		2				2			
				84430		6							
MS21209C0815 *MS21209C0815* Heli Coil, screw locking, red		Purchased	No			100	Each	62.0000	4	8			
									**			(2) FF 12-07-09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST304		62							
				118159		1							
				119316		61				8			
MS21209C6-10 *MS21209C6-10* Heli Coil, screw locking, red		Purchased	No			100	Each	12.0000	1	2			
									**			(2) FF 12-07-09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST304		12							
				108847		12				2			

W/O:		WORK ORDER CHANGES					
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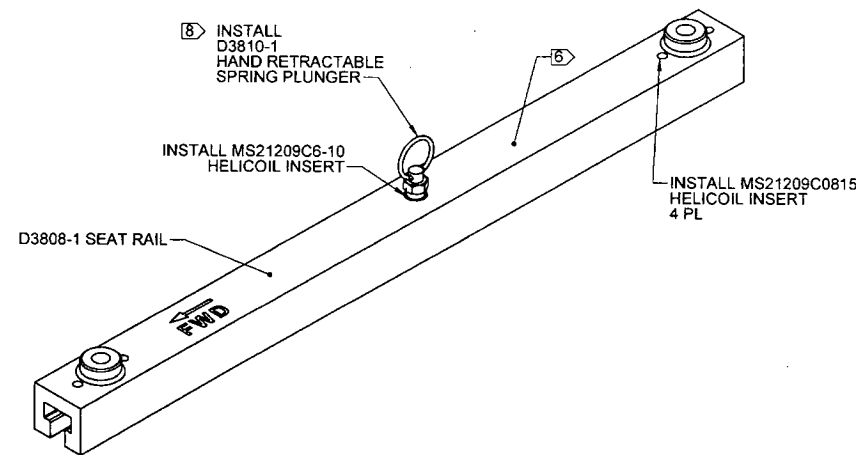
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NOTE: Date & initial all entries

QTY -041	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)



D3808-041 SEAT RAIL ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 861354L5
12/06/21

RELEASED
02-09-20 11/8

D3808-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

A	NEW ISSUE	RF	08.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3808** REV. A
SHEET 1 OF 2
TITLE **SEAT RAIL ASSEMBLY** SCALE NTS

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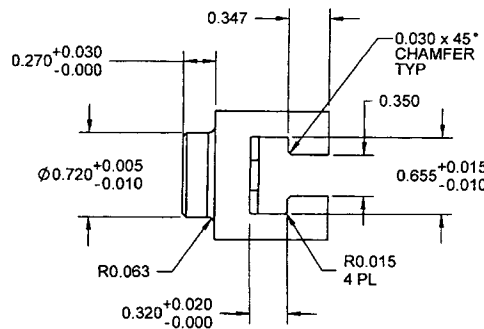
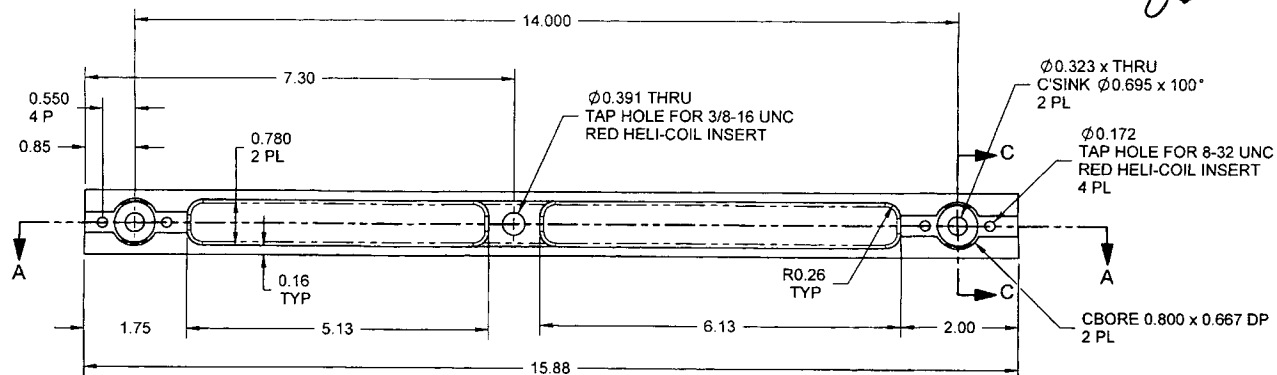
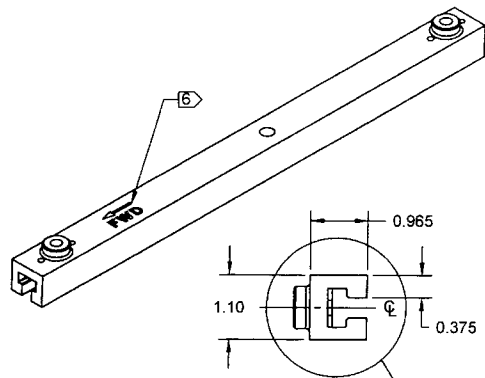
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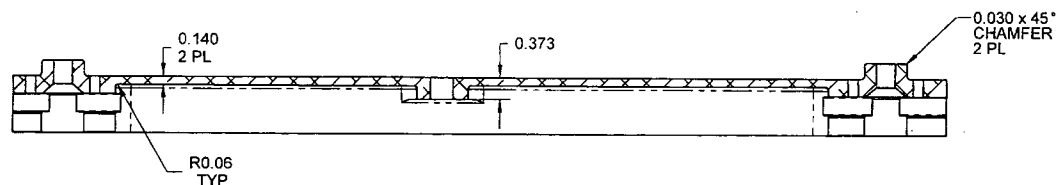
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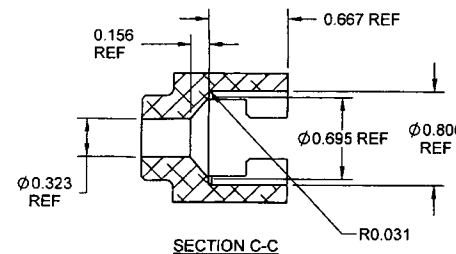
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DETAIL VIEW B



SECTION A-A







SECTION C-C

D3808-1 SEAT RAIL

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3808	SHEET 2 OF 2
APPROVED			TITLE	SCALE
DE APPR.			SEAT RAIL ASSEMBLY	NTS
DATE	08.08.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD		
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RELEASED
108-1-30-114

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